EXECUTIVE 385

STAINLESS STEEL
SOLID WIRE TECHNICAL DATA SHEET

DESCRIPTION

Executive 385 wire is designed to provide clean and consistent welds with excellent feedability and minimal clean-up. By maintaining tight control from the country of melt to the design of the spool Executive wire provides welders with the highest quality stainless bare wire.

Executive 385 (904L) weld metal has an austenite structure with 20% Cr, 25% N, -4.7% Mo, 1.5% Cu.

APPLICATIONS & FEATURES

Executive 385 is used primarily in environments designed for the handling of sulphuric acid and other corrosive media as well as, process piping, and vessel manufacturing.

The elements Carbon, Silicon, Phosphorus and Sulfur specified at lower maximum levels to minimize weld metal hot cracking and fissuring (while maintaining corrosion resistance) frequently encountered in fully austenitic weld metals.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Cr	Ni	Mo	Mn	Si	P	S	Cu	N
0.008	19.93	25.00	4.28	1.61	0.35	0.010	0.0005	1.33	0.048

Tensile Strength: 78,300 PSI min
Yield Strength: 49,300 PSI min
Elongation: 37%

TYPICAL WELDING PARAMETERS

Process	Diameter	Voltage	Amperage	Gas Flow	Shielding Gas / Flux
GMAW - Short	.035"	21-22	160-200	30 to 50 CFH	98% Ar / 2% O_2
	.045"	22-23	180-210		
- Spray	.035"	23-25	190-260		90% Ar / 10% O_2
	.045"	25-28	250-330		
GTAW	.093"	Direct Current; Electrode -		30 to 40 CFH	100% Ar
SAW	.093"	29-32	300-350		Record IN Flux
	.125"	29-32	400-550		

STANDARD PACKAGING

GMAW (MIG)	33-lb wire baskets	1,980-lb pallet
	11-lb plastic spools	11-lb box
	2-lb plastic spools	8-lb box
GTAW (TIG)	10-lb plastic tube	40-lb box
SAW	60-lb wire coil	1,200-lb pallet

CLASSIFICATION

AWS/SFA 5.9, Class **ER385**